

Work Order ID 120876

December-22-14 8:27:43 AM

Report

120876

Page 1

Item ID: D2512 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Lid
 Start Date: 6/16/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 6/27/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: *U* Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2512	G

100 Weld per dwg A/R S.S. rod Batch: B125054 0.00
 Large Fab

100

Large Fab

Large Fab

Memo 0.00

1- Weld ribs as per Dwg D2512 using Welding Jig DT 9436

INSTALL D2012-117 CLEVIS ONLY ON D130-701-XXX

2- WELD MESH AND REMOVE SECTIONS OF MESH WHERE
 INDICATED AS PER DWG

IX CC 14-12-22

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Quality Control

Memo 0.00

DAS
 24
 9-89

DEC 23 2014

Page 2

1 15-1-6 JGL

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Item ID: D2512 Accept ***N900040100*** Setup Start ***NS1***
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 Item Name: Basket Lid
 Start Date: 6/16/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 6/27/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00							DAS 38 9-89
150									
QC	Memo	0.00							
Quality Control									JAN 07 2015
160	Identify as per dwg & Stock Location: <u>w/g</u>	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

D350-607-041A/B120876 1x 15/01/07

MLJ 15-01-09
 MLJ 15-01-09

Picklist Print

December-22-14 8:27:42 AM

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Work Order ID: 120876

120876

Parent Item: D2512

D2512

Parent Item Name: Basket Lid

Start Date: 6/16/14

Required Date: 6/27/14

Start Qty: 1.00

Required Qty: 1.00

Comments: Rev IPP:M03.01.31 AddedD2012-117forD130-701-041KJ/RF
IPP Rev:N 06.04.05 Added level21 EC
IPP REV:O ADDED D3490-1/-3 FOR D130-701-011/-043 10-04-20 JLM
VERIFIED BY:DD
IPP Rev:P 08-08-29 revE as per dwg DD verified by:EC
IPP Rev:Q 08-09-24 plug holes prior to powder coating DD verified
by:EC IPP Rev:R
10.06.29 added pressure wash DD verf:EC IPP REV:S 12.07.27 AS
PER DWG REV.F DD VERF:EC IPP REV:T 12.08.08 AS PER DWG
REV.G DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2012-117

Manufactured No

100

Each

20.0000

2

2

D2012-117

Clevis

CL 15-1-9

Location

WA004

Loc Qty

20

Loc Code

124563

11

125440

9

*** ONLY APPLICABLE ON D130-701-041 -IF
NOT USED, PLEASE MARK N/A ***

D2232-1

Manufactured No

100

Each

39.0000

2

2

D2232-1

Basket Hinge

CL 14-12-22

Location

WA004

Loc Qty

39

Loc Code

105333

15

105885

24

(2x)

Picklist Print

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Work Order ID: 120876

120876

Parent Item: D2512

D2512

Parent Item Name: Basket Lid

Start Date: 6/16/14

Required Date: 6/27/14

Start Qty: 1.00

Required Qty: 1.00

D2236

Manufactured No

100

Each

8.0000

4

4

D2236

Lid Rib

**

CC 14-12-22

Location

Loc Qty

Loc Code

WA004

8

124995

8

(4x)

D2506

Manufactured No

100

Each

24.0000

1

1

D2506

Label Plate

**

CC 14-12-22

Location

Loc Qty

Loc Code

WA004

24

102257

17

103156

2

99826

5

(1x)

D2512-3

Manufactured No

100

Each

2.0000

2

2

D2512-3

Rib

**

CC 14-12-22

Location

Loc Qty

Loc Code

WA004

2

105310

2

B125143

(2x)

D2512-5

Manufactured No

100

Each

6.0000

6

6

D2512-5

Rib

**

CC 14-12-22

Location

Loc Qty

Loc Code

WA004

6

124956

6

(6x)

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Shop Packet Print

Page 2

Picklist Print

December-22-14 8:27:42 AM

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Work Order ID: 120876

120876

Parent Item: D2512

D2512

Parent Item Name: Basket Lid

Start Date: 6/16/14

Required Date: 6/27/14

Start Qty: 1.00

Required Qty: 1.00

D2512-7

Manufactured No

100

Each

2.0000

3

3

D2512-7

Rib

**

CC 14-12-22



Location

Loc Qty

Loc Code

WA004

2

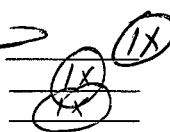
B125424

107695

1

97300

1



D2581

Manufactured No

100

Each

98.0000

2

2

D2581

Mounting Bracket

**

CC 14-12-22

Location

Loc Qty

Loc Code

WA004

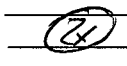
98

102265

58

122730

40



D3825-043

Manufactured No

100

Each

6.0000

2

2

D3825-043

Rib Assembly (Basket End, Lid)

**

CC 14-12-22

Location

Loc Qty

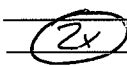
Loc Code

WA004

6

124955

6



D3832-13

Manufactured No

100

Each

2.0000

1

1

D3832-13

Mesh (Lid)

**

CC 14-12-22

Location

Loc Qty

Loc Code

WA004

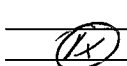
2

125085

1

125086

1



Picklist Print

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Work Order ID: 120876

120876

Parent Item: D2512

D2512

Parent Item Name: Basket Lid

Start Date: 6/16/14

Required Date: 6/27/14

Start Qty: 1.00

Required Qty: 1.00

D3833-7

Manufactured No

100

Each

13.0000

2

2

D3833-7

Mesh (Lid End)

11/14-12-22

Location

WA006

105442
114377

Loc Qty

Loc Code

13 ~~8177778~~

1

12 417178

(Handwritten marks: circled numbers and arrows)

Work Order Summary

December-22-14 8:27:22 AM

Page 1 of 1

Criteria : Work Order ID: 120876 Item ID: D2512 Product Family LARGE FAB
 Work Order Start Dates 6/16/14 to 6/16/14 11:59:59 PM Work Order Required Dates 6/27/14 to 6/27/14
 11:59:59 PM

All References

Work Order Status Released

Work Order ID	120876	Required Qty	1.0000	Status Code	Released
Item ID	D2512	Accepted Qty	0.0000	Scrap Qty	0.0000

Item Name Basket Lid

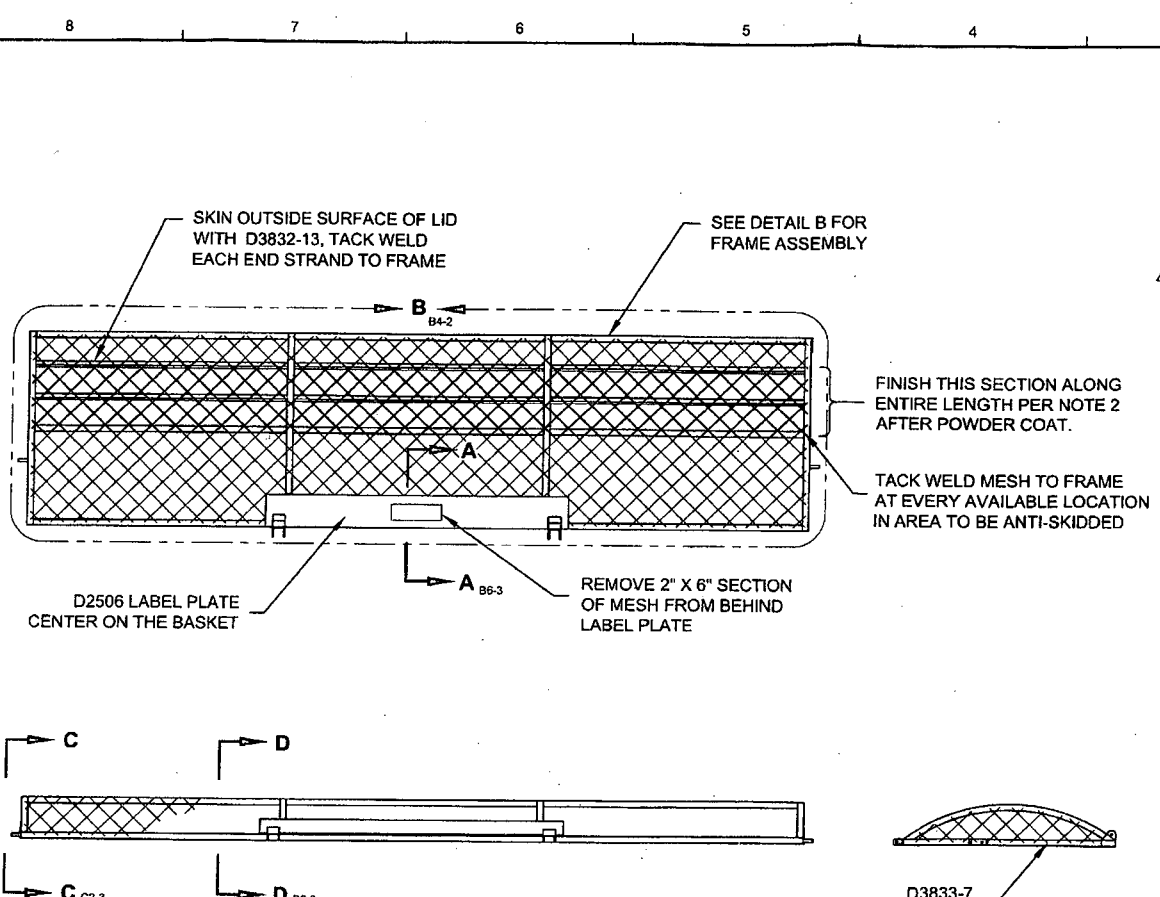
Current Acct Value \$1,935.548

Start Date	6/16/14	Required Date	6/27/14	Completed Date	
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Standard	** Actual **		** Acct. Value **	** Variance **	** Variance % **
<u>Direct Costs</u>	<u>Total</u>	<u>Each</u>	<u>Each</u>	<u>Each</u>	<u>Each</u>
Material	\$0.000	\$0.000	\$197.091	\$197.091	100.00%
Labor	\$336.857	\$0.000	\$558.973	\$558.973	100.00%
Outplant	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Variable Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Fixed Burden	\$808.546	\$0.000	\$1,321.748	\$1,321.748	100.00%
Material Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
** Total **	\$1,145.403	\$0.000	\$2,077.812	\$2,077.812	

Work Center Large Fab

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
CRUI01												
	12/16/14											
100			0.00	0.00	5.11	5.11	1.00	\$0.000	\$114.098	\$273.865	\$0.000	\$387.96
100			0.00	0.00	0.59	0.59	1.00	\$0.000	\$13.051	\$31.327	\$0.000	\$44.37
	12/18/14											
100			0.00	0.00	9.40	9.40	1.00	\$0.000	\$209.707	\$503.354	\$0.000	\$713.06
Total:			0.00	0.00	15.10	15.10	3.00	\$0.000	\$336.857	\$808.546	\$0.000	\$1,145.40



QTY	PART NUMBER	DESCRIPTION
X	D2512	BASKET LID ASSEMBLY
2	D2512-3	RIB
6	D2512-5	RIB
3	D2512-7	RIB
2	D2232-1	HINGE PLATE
4	D2236	RIB
1	D2506	LABEL PLATE
2	D2581	MOUNTING BRACKET
2	D3825-043	RIB ASSY (BASKET END, LID)
1	D3832-13	MESH (LID)
2	D3833-7	MESH, LID END

W/O
120876

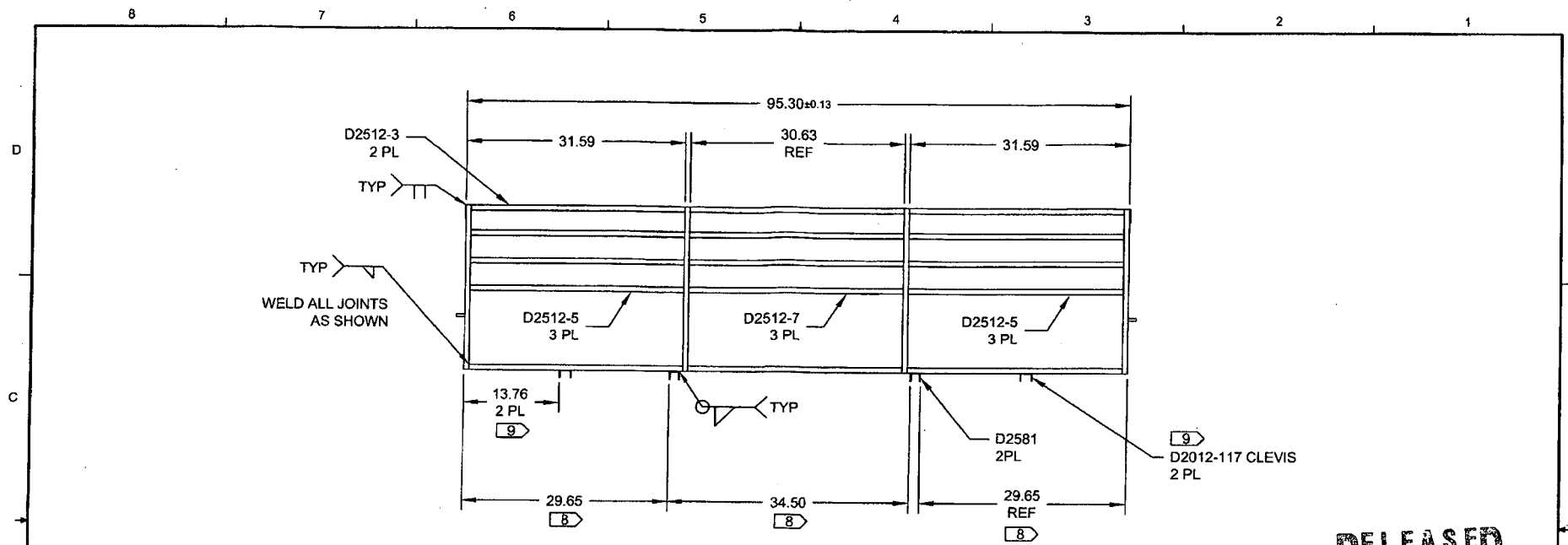
RELEASED
2012-00-03

G	CORRECTED TYPO: D3825-043 WAS D3825-041 (ZN D3-1, B8-2, B1-2)	MB	12.07.26
F	GENERAL REVISION: REFORMATED DWG; DELETED DETAIL E AND RELATED NOTES IN VIEW C-C. REASON: PAR10-50.	MB	12.05.11
E	INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3 ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERRED TO "B" FORMAT AND UPADTED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. G
MFG. APPR.		D2512	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	12.07.26	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

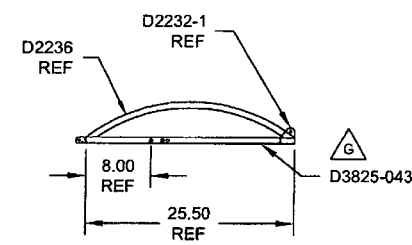
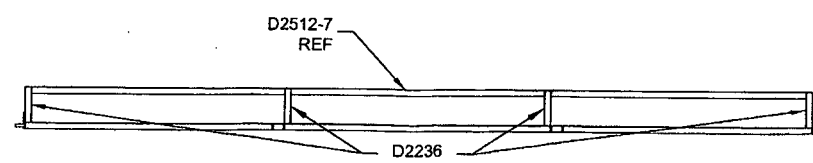
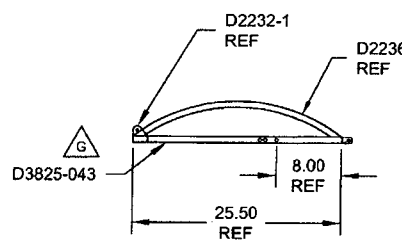
D2512 BASKET LID ASSEMBLY NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
AFTER POWDER COAT, SPRAY PAINT BLACK INSIDE SURFACE AND
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACES PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004



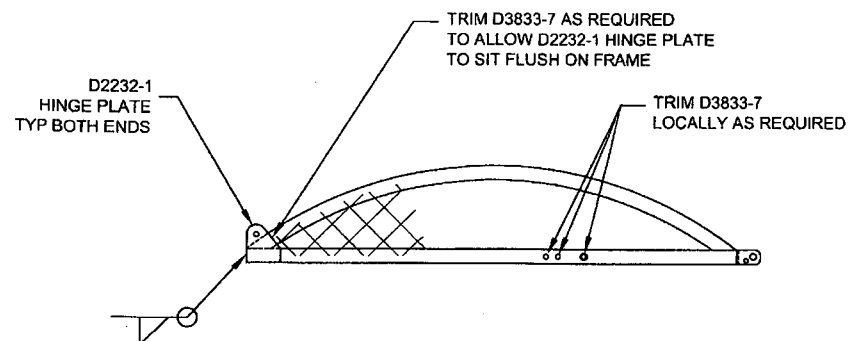
DETAIL B D6-1
FRAMEWORK ONLY SHOWN FOR CLARITY

RELEASED
2012-08-03
JW

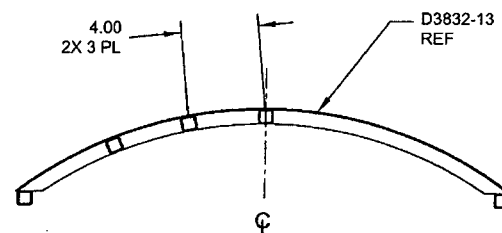


- NOTES:**
- 1) MATERIAL: NONE
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: N/A
 - 8) LOCATE IN CONJUNCTION WITH ADJACENT D2581 ON BASKET BASE ASSEMBLY
 - 9) FOR D130-701-041 ONLY

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. G
MFG. APPR.		D2512	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
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VIEW C-C SIMILAR BOTH END RIBS B8-1

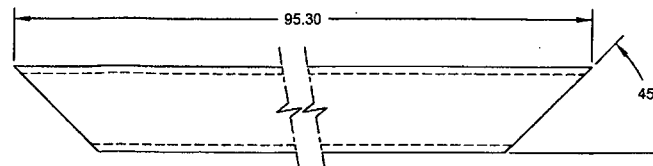
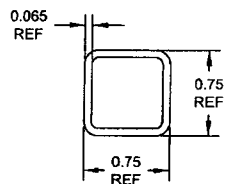


SECTION D-D SAME BOTH CENTER RIBS B7-1

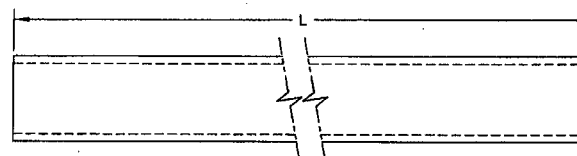
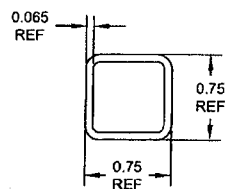
RELEASED
2012-08-03
wmp

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. G
MFG. APPR.	<i>[Signature]</i>	D2512	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET LID ASSEMBLY (350/212)	
DATE	12.07.26	NTS	

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D2512-3 RIB



D2512-X RIB

DART PART NUMBER	L
D2512-5	30.84
D2512-7	30.63

RELEASED
2012-08-03

D2512-5/-7 NOTES:

- 1) MATERIAL: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBING
PER ASTM A554/A269 MILL FINISH, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC M304TS0.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	5		
CHECKED	ASS	DRAWING NO.	REV. G
MFG. APPR.	[Signature]	D2512	SHEET 4 OF 4
APPROVED	[Signature]	TITLE	SCALE
DE APPR.	[Signature]	BASKET LID ASSEMBLY (350/212)	NTS
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